

Date: Tuesday, 29/04/2008 8:26:21 AM
 User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: SLIDING DOOR BRACKET		
Job Number	38804			Part Number	: D36751		
Estimate Number	13275			Drawing Number	: D3675 REVA PRELIM		
P.O. Number	:			Project Number	: N/A		
This Issue	29/04/2008	S.O. No.	:	Drawing Revision	: A PRELIM		
Prsht Rev.	NC			Material	:		
First Issue	25/04/2008	Type	SMALL /MED FAB	Due Date	02/05/2008	Qty:	12 Um: Each
Previous Run	:						
Written By	<i>JL/08-05-25</i>						
Checked & Approved By							
Comment	Est Rev:A	new issue	08-04-21	DD verified by:EC			

Additional Product

PROTOTYPE

FOR ENGINEERING USE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.1271 sf(s)/Unit Total : 1.5246 sf(s)

304 stainless steel 0.032" Sheet

Batch: *M107744*

HB 8-4-28



2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3675

Dwg Rev: *A*

Prog Rev: *A*

HB 8-4-28



2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



HB 8-4-28



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JL/08-05-29

(12)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Form as per Dwg D3675

SB 08/04/29 (12)

Date: Tuesday, 29/04/2008 8:26:21 AM

User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDING DOOR BRACKET

Job Number: 38804

Part Number: D36751

Job Number:



Seq. #: Machine Or Operation:

6.0 QC5

**ENGINEERING**

INSPECT WORK TO CURRENT STEP

APPROVAL

ASQ 08/04/29



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



11 10 5 08/04/29

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 8:50AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:20AM

08 08/05/05 (12)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

08/05/09

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/09 (12)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Champ 08/05/09
10

08/05/09

8

7

6

5

4

3

2

1

D

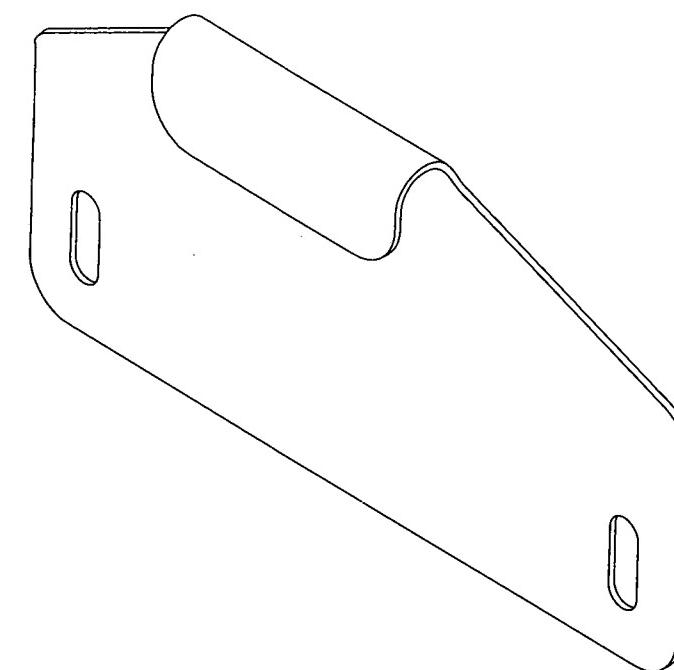
D

C

C

B

B



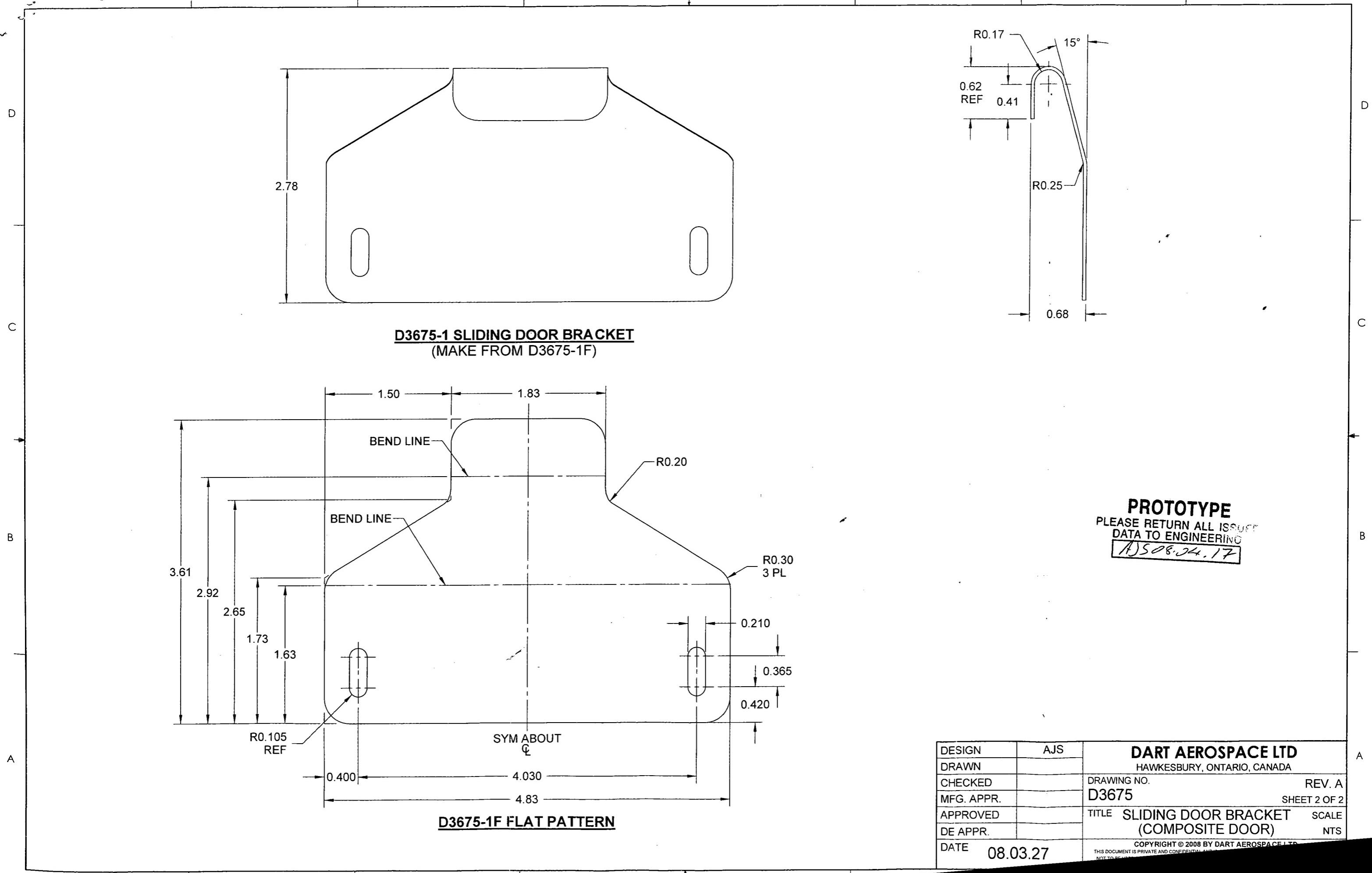
D3675-1 SLIDING DOOR BRACKET

PROTOTYPE
PLEASE RETURN ALL ISSUES
DATA TO ENGINEERING
AJS 08.04.17

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3675	REV. A
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.	:		SHEET 1 OF 2
DATE			(08.03.27)



DART AEROSPACE LTD	Work Order:	38864
Description: SLIDING DOOR BRACKET	Part Number:	D3675-1
Inspection Dwg: 3675-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	18	Audited by:	Suraj	Prototype Approval:	NSS
Date:	08-04-28	Date:	08-04-29	Date:	08-04-29

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	